



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

5170295

RBW6521A00146W142C-3T-1
Job Sheet 192607-A



Part No: RBW6521A00146W142C-3T-1 **Job Qty:** 1 pcs

Part Name: Shaft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/6/19

Job Tracking No:

Due Date: 4/19/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBW6521A00146W142C-3T Rev.A IPP Rev. A 19.03.18 New issue DP Verify DD/IPP Rev. B 19.04.01 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
160	Packaging 3-1 - Stock - B4B	1 pcs	4/19/19	4/19/19	0.00	0.00	Packaging 3 - 1 - B4B		
170	QC 21 - SA	1 pcs	4/19/19	4/19/19	0.00	0.00	QC 21 - SA - 21		
							QC 21 - SA - 70		

DAG
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3-33

MAY 06 2019

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

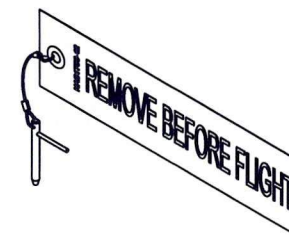
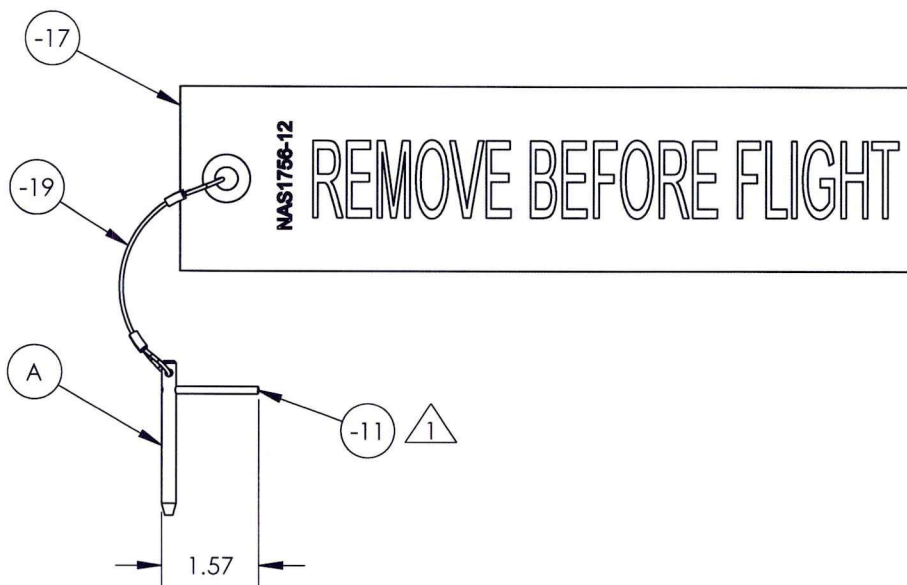
Part Specifications

Specifications could not be found.

Plex 5/6/19 12:45 PM dart.lacelle.linda

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	16-0281	-01, -03, -05, -07, -09 ADDED FINSH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE 	1/12/2017	RJC	JAG



ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

NOTE:

1 USE LOCTITE 680 TO ASSEMBLE.

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01	REV 6
MAT'L HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:3	DATE 9/11/2009 SHEET 2 OF 3

-01, -03, -05, -07, -09

PIN



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RBW6521A00146W142C-3T-

1

Job Sheet 192607



Part No: RBW6521A00146W142C-3T-1 **Job Qty:** 4 pcs

Part Name: Shaft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/28/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6521A00146W142C-3T Rev. 0 IPP Rev. A 19.03.18 New issue DP Verify DD

Ship Via:

A OK 2019-4-15

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Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	4 pcs	4/19/19		0.00	2.00	Conventional Lathe - 1		
							Conventional Lathe - 2		
110	QC 2	4 pcs	4/19/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S172531



Part: RBW6521A00146W142C-3T-1

Job No: 192607

Serial No/Batch: S172531

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/15/19

120 QC 8	4 pcs	4/19/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Outsource - 4 - Anodize	4 pcs	4/19/19		GRO002-VC	5 04/18/2019 PL
140 Packaging 2-1 - Receive - B4B	4 pcs	4/19/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	

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					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150 QC 6	4 pcs	4/19/19	0.00 0.00		QC 6 - 9	DAS
					QC 6 - 68	APR 30 2019 68
					QC 6 - 61	9-89
160 Packaging 3-1 - Stock - B4B	4 pcs	4/19/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	26
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	4/19/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	

Part Op 100 - 1-Machine as per DWG. 2-Deburr
 Descriptions: 120 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 130 - Issue P/O: 043245 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -
 Material type; 6061T6 -Certificate of Conformity is required

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.625	6061T6 Round Bar 1.625	1.7200 ft (.43 ea)	100-Conventional Lathe - 1	SOP10.366

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Conventional Lathe - 1	M6061T6R1.625	2	6	0

Part Specifications

Specifications could not be found.

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INSPECTION SHEET

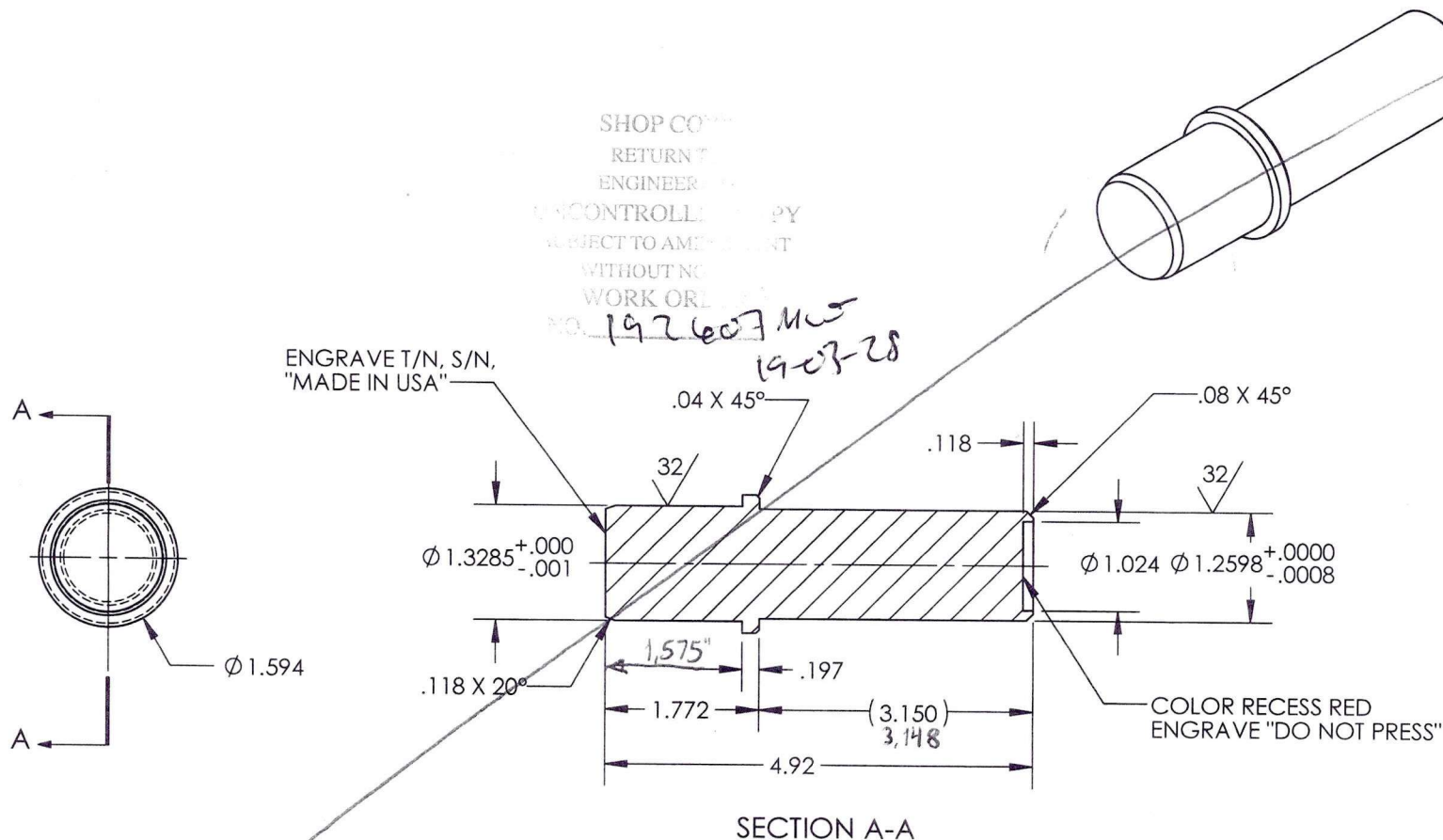
~~DAS~~

68Date:Revised by

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REV		DESCRIPTION	REVISIONS	DATE	INITIAL	APPROVED

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORIGIN
NO. 192607 MJS
19-03-28



(-1)
SHAFT

 RED BARN MACHINE	
TITLE SEAL PRESS TOOL	
DWG NO. RBW6521A00146W142C-3T-1	
MAT'L 6061 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: GILBERT APPROVED <i>D. Weil</i> HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I USED ON MODEL AW139
SCALE 1:2	DATE 7/17/2012
SHEET 2 OF 4	

Entered: _____ Date: _____

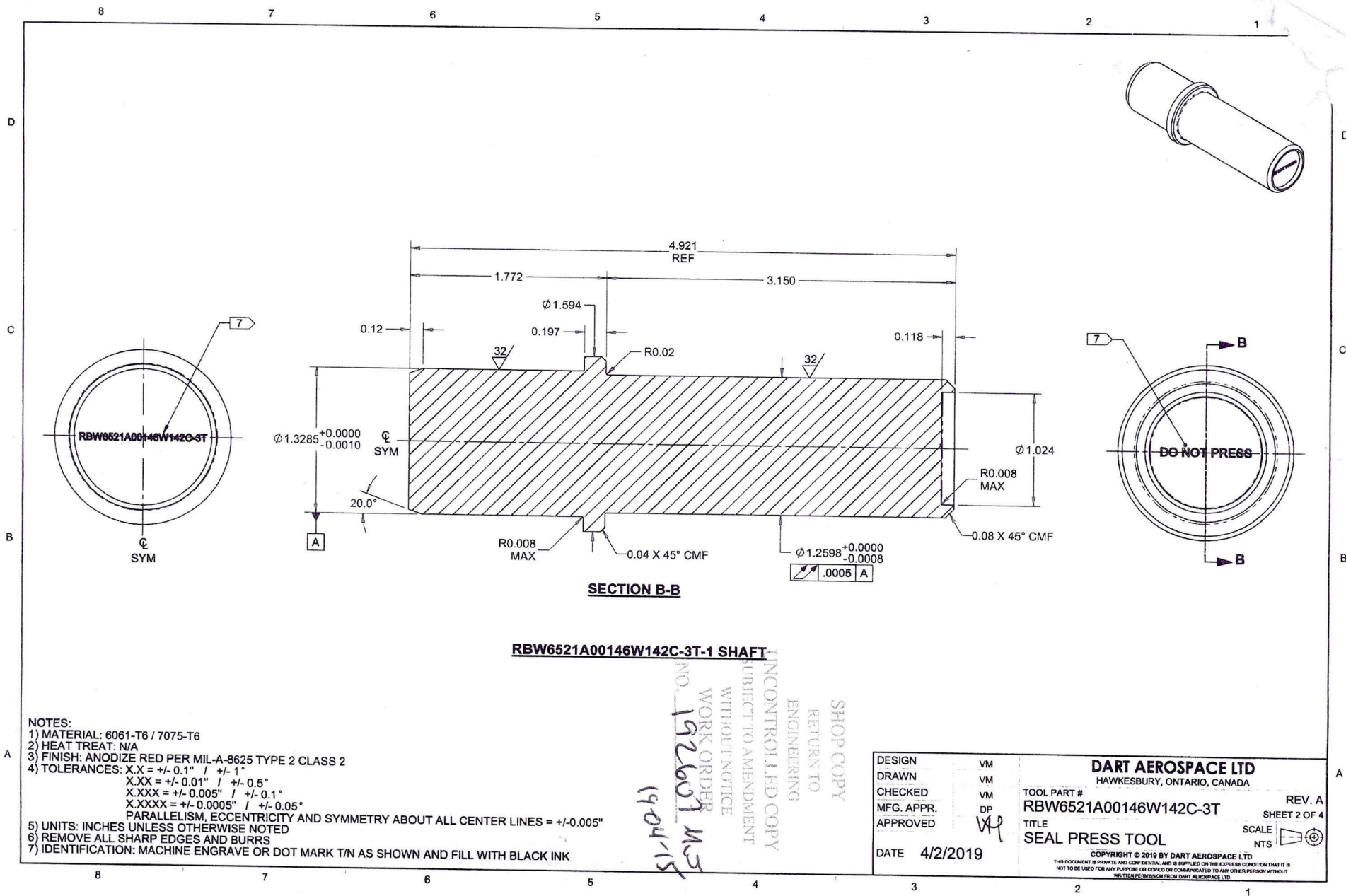


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>192607</u> Part No. <u>RBW6521A00146W142C-3T</u> <u>REV A.</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : <u>4/15/19</u>		Sequence #: _____		QTY Affected : _____		MRB (QSI042) 	
Description Work Order Deviation				Disposition			
DIMENSION 1.2598 ± 0.0008 ACCEPTABLE TO BE 1.2598 ± 0.0015				-THIS DEVIATION IS ACCEPTABLE TO USE AS IS -THE FIT FORM AND FUNCTION WILL BE AS ORIGINALLY INTENDED			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled				FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
Other/Details: _____				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator DAS 68 9-89 APR 30 2019			





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043245



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043245

PO Date: 4/18/19

Due Date: 4/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182090	C10-2	Side Plate - MRK -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/26/19	6 pcs	0 pcs	6 pcs	\$12.50/pcs	\$75.00
2	192870	20NR-02	Solenoid Cover -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/26/19	21 pcs	0 pcs	21 pcs	\$4.25/pcs	\$89.25



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PURCHASE ORDER

PO043245



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	192957	RBE703A94-1130-01-09	Bottom Fixture 2 -Issue P/O: PO ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2 WATER SEALANT -Certificate of Conformity is required	Firmed	-	4/26/19	6 pcs	0 pcs	6 pcs	\$5.50/pcs	\$33.00
				6 X		APR 30 2019					
4	189332	RBE703A94-1130-01-03	Bottom Fixture 1 -Issue P/O: PO ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2 WATER SEALANT -Certificate of Conformity is required	Firmed	-	4/26/19	10 pcs	0 pcs	10 pcs	\$5.50/pcs	\$55.00
				10 X		APR 30 2019					
5	192607	RBW6521A00146W142C-3T-1	Shaft -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/26/19	4 pcs	0 pcs	4 pcs	\$4.75/pcs	\$19.00
				4 X		APR 30 2019					

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Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043245



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	193428	RBW6521A00146W142C-3T-2	Housing -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/26/19	4 pcs	0 pcs	4 pcs	\$3.95/pcs	\$15.80
Grand Total:											\$287.05

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/22/19 11:33 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018613-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018613- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
29-Apr-2019		Jessie Boisvert		PO043245				
#Ligne Line#	No. de Série / # Pièce Part Number / Line-Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C10-2 Rev.	C10-28A 01 -ANO-BLACK [ANODIZE BLACK] 8625F TYPE 2 CLASS 2, WATER SEALANT	ANODIZE CH	6	6	0	0	0
2	20NR-02 Rev.	20NR-02 01 -ANO-BLACK [ANODIZE BLACK] IAW MIL-A--8625F TYPE2 CLASS 2 WATER SEALANT-MATERIAL TYPE; 6061T6	ANODIZE CH	21	21	0	0	0
3	RBE703A94-1130-01-09 Rev.	RBE703A94-1130-01-09 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0
4	RBE703A94-1130-01-03 Rev.	RBE703A94-1130-01-03 01 -ANO-RED [ANODIZE RED] IAW MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0
5	RBW6521A00146W142C-3T-1 Rev.	RBW6521A00146W142C-3T-1 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	4	4	0	0	0
6	RBW6521A00146W142C-3T-2 Rev.	RBW6521A00146W142C-3T-2 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE-2 CLASS-2	ANODIZE CH	4	4	0	0	0

DAS
68
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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.